| Work Orde Thursday, June 2 | | | | | *121 | 1526* | | | | | | | Page 1 |
|---------------------------------|-------------------------------|-----------------------|--|------------|---|-------------|------------|--------------|--------------|--------------|---------------|------------------|-----------------|
| Item ID: Revision ID: | D3436-044 | | | | Accept | *N900 | <u>040</u> | 100 |)* | Setup | Start Stop | 171 | S1* |
| Required Date: | Step RH 6/26/14 6/26/14 | Start Qt Req'd Q | - | *?* | | Cust Item I | ID: | | | | • | ^IXI; | S2* |
| Reference: Approvals: | Process Pla QC: | n: <u>M</u> L | .5 | Date: \\ \ | | | ate: | _ | | Run | Start Stop | | R1* R2* |
| Sequence ID/ Work Center II | D | Operatio Descripti | | | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accep Qty | t Rej Qty | | Reject Number | Insp. Stamp |
| Draw Nbr | Rev | ision Nbr | | | | | | | | | | | 4 0 |
| D3436 | Rev | Α . | | | | | | | | , | | | 14-09-0 |
| 100 *100 Large Fab | | Large Fab | Memo | - | 0.00 | | | | 2 | | | | 14-09-l J130 |
| Large Fab | | | Weld bushind Dwg D343 Qty Par A/RN/A Weld right Rev: A/RN/A Weld cap I | 6Dwg Rev: | elding Jig DT8773 and Dwg E nd 12 1945 3436Dwg Rev: A | | | | | | | | |

| DQA: | | | Date: | | | WORK ORDER NON | -00 | NEO | RMANCE / LID | DATE | | | DART |
|---------------|------------------------------|-----------|-------------|---|-------------|--------------------------------|-----|---------|---------------------|-------------------------------------|--------------|-------------------------------|--------------------|
| QA Closed: | | | Date: | | | WORK ORDER NOW | | | MINIANCE / OI | | Vork Order u | odate only | AEROSPACE |
| | | | | | | DISPOSITION | | | | AGAINST D | EPARTMENT | /PROCESS | |
| Work Ord | er: | | | | | _ , | 1 Î | | s | с г | 7 | Water Jet | Engineering |
| Part I | No. | | | | | Rework Scrap | | | Skid-tube Machining | Crosstube Small Fab Finishing | | d. Eng. Coor. re/Packaging | Quality Other |
| NCR I | ۷o. ِ | | | . <u>. </u> | | Use-as-is Suspected Unapproved |] | mern | noforming Large Fab | Composite | | Supplier | J |
| Root | - | | | | Desc | ription of work order update | | nitial | Acti | on | Sign & | | |
| Cause | | Date | Step | Qty | | or non-conformance | Ch | ief Eng | Descri | ption | Date | Verification | QC Inspector |
| Design | | | | | | | | | | | | | |
| Doc/Data | | | | | | | | | | | | | |
| Equip/Tooling | | | | | 1 | | ļ | | | | | | · |
| Handling/Pre | | | | | | | | | | | | | |
| Material | | | | | 1 | | Ì | | | | | | |
| Operator | | | | | | | | | | | | | |
| Offset/Setup | up | | | | | | | | | | | | |
| Process · | | | ŀ | | | | | | | | | | |
| Supplier | | | | | | | | | | | | | |
| Training | | | | | | | | | | | | 1 | |
| Transport | | | | | | | ł | | | | | | · |
| Unapproved | | | , | | | | | | | | | | |
| | | | | | | | FA | ULT CA | TEGORY | | | | |
| Landi | ng (| Gear | | | | General | | _ | | | <u></u> | - | |
| | | Bending | | | | Bend | | Folio/F | Program | L | Outside Din | nensions | Pressure/Forced |
| | | Centre N | ot Conce | ntric | | BOM/Route | | Grain | | L | Over/Unde | tolerance | Set-up |
| | | Cracks | | | | Broken/Damage/Defect | | Hardwa | are | | Part Incorre | ci | Temperature/Cure |
| | Crimp/Kink/Ripple/Wave Burrs | | | | | Burrs | | Inspect | ion Incomplete/Un | qualified | Part Lost/M | issing | Weld |
| | Cuffs Contamination | | | | | Contamination | | Instruc | tions Incomplete/U | Inclear | Part Moved | L | Wrong Stock Pulled |
| | | Crushing | | | | Countersink | | Misali | gned/off center | | Positioned ' | Wrong | |
| | | Heat Trea | at | | | Cut Too Short | | Mislabe | eled . | | Power Loss | /Surge [| Other |
| | | Inspectio | n Strip in | Tube | | Drawing | | Misrea | d | _ | | | |
| | | Marks/Cl | hatter | | | Drill Holes | | Off-set | | | | | |
| | Turning Sequence Finish | | | | | | | Out of | Calibration | | | | |
| | | Wave/Tv | vist in Tul | be | | Fit/Function | | Out of | Sequence | | | | |

| Work Ord Thursday, June | | | | *12 | 1526* | | | | | , | Pag | ge 2 |
|--|----------------------|--------------------------|-------|----------------------|------------------|--------|--------------|---------------|---------------|-----------------|------------------|------|
| Item ID: Revision ID: Item Name: | D3436-044 Step RH | | | Accept | *N900 | 040 | 100 |) * ፡ | - | | JS1* JS2* | |
| Start Date: | 6/26/14 | Start Qty: 2.00 | *2* | | Cust Item | ID: | | | | | | |
| Required Date | e: 6/26/14 | Req'd Qty: 2.00 | *2* | | Customer: | | | | | | | |
| Reference: | | | - | | | | | | _ | | | |
| Approvals: | Process Pla | an: | Date: | Tooling: | D | ate: | | F | | _ | JR1* | k |
| | QC: | | Date: | SPC (Y/N): | D | ate: | | | Si | */ | JR2* | r |
| Sequence ID/ Work Center | ID | Operation Description | | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Numbe | Insp. r Stamp | |
| . ¹¹⁰ *11 0 * | | BAND SAW | | 0.00 | | | | 2 | | | 14- | -04 |

120 *120*

Bandsaw

Jeaspa Bandsaw

QC9- Inspect visual per QSI004- Fusion Welds

1-Slit part D3436-041 on bandsaw as per Dwg D3436

0.00

0.00

0.00

SEP 1 0 2014

DAS 24 9-89

Quality Control

130

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

Memo

2- deburr

Memo

0.00

SEP 1 0 2014

DAS 24

Quality Control

9-89

| DQA: | | | . Date: | | | | | | | | | | | TAART |
|----------------------|----------------------|-----------|-------------|------------|----------|------------------------------|----------|----------|------------------|-------------|----------|--------------|---------------|--------------------|
| ••• | | | Data | | | WORK ORDER NON- | -CC | ONFO | RMANCE / U | | 1 | ork Order up | odata only | AEROSPACE |
| QA Closed: | | | Date: | | | | | <u> </u> | | | VV | ork Order up | date only | |
| Work Orde | ·r· | | | | | DISPOSITION | | | | AGAINST | DE | PARTMENT | /PROCESS | |
| Work Orac | ··· - | | <u>_</u> | | | Rework | | | Skid-tube | Crosstube | | 1 | Water Jet | Engineering |
| Part N | lo. | | | | | Scrap | | | Machining | Small Fab | | Pro | d. Eng. Coor. | Quality |
| | - | | • | | | Use-as-is | | | noforming | Finishing | | Rec/Sto | re/Packaging | Other |
| NCR N | lo. | | | | | Suspected Unapproved | | | Large Fab | Composite | | | Supplier | |
| | • | | | | | | | | | | | · · | | |
| Root | | | | | Desci | ription of work order update | | Initial | | tion | | Sign & | | |
| Cause | | Date | Step | Qty | | or non-conformance | Ch | ief Eng | Desc | ription | | Date | Verification | QC Inspector |
| Design | | • | | | | | | | | | | | | |
| Doc/Data | _ | | | | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | | | | | |
| Handling/Pre | _ | | | | | | | | | | | | | |
| Material | | | | | | | | | | | | | | |
| Operator | | | | | | | | | , | | | | | |
| Offset/Setup | | | | | | | | | | | | | | |
| Process | \dashv | | | | | | | | | | | | | |
| Supplier Training | | | ' | | | | | | | | | | | |
| Transport | \dashv | 2314 | 1 43 |] . | | | | | | | | | | |
| Unapproved | | 1165 | 1 (22) | ľ | | | Ì | | | | | | | |
| | | | I | <u> </u> | | | FA | ULT CA | TEGORY | | | <u></u> | <u> </u> | |
| Landi | ng G | Gear | | | | General | | | | | | | | |
| | | Bending | | | | Bend | | Folio/F | rogram | | | Outside Dim | ensions | Pressure/Forced |
| | | Centre No | ot Concer | ntric | | BOM/Route | | Grain | | | | Over/Under | tolerance | Set-up |
| | | Cracks : | 91 74 | مر | | Broken/Damage/Defect | | Hardwa | ire | | | Part Incorre | cí <u> </u> | Temperature/Cure |
| , | | Crimp/Kir | nk/Ripple | /Wave | | Burrs | | Inspect | ion Incomplete/U | Inqualified | | Part Lost/M | issing | Weld |
| | Cuffs Contamination | | | | | | | 4 | ions Incomplete/ | 'Unclear | | Part Moved | | Wrong Stock Pulled |
| | Crushing Countersink | | | | | | | - | ned/off center | | L | Positioned V | | , |
| | \vdash | Heat Trea | | | | Cut Too Short | _ | Mislabe | | | <u></u> | Power Loss/ | Surge | Other |
| | | Inspectio | | Tube | <u> </u> | Drawing | | Misread | | | | | | · |
| | | Marks/Ch | | | - | Drill Holes | | Off-set | | | | | | |
| | L | Turning S | | | | Finish | <u>_</u> | -1 | Calibration | | | | | |
| · | 1 | Wave/Tw | vist in Tub | oe | | Fit/Function | | Out of : | Sequence | | | | - | |

| Work Ord | | | | *121 | 1526* | | • | | | | | Pag |
|--|----------------------|---|--|------------------------|--------------------------|------------|--------------|---------------|--------------|---------------|------------------|----------------|
| Item ID: Revision ID: Item Name: | D3436-044 Step RH | | | Accept | *N900 | <u>040</u> | 100 |)* | Setup | Start Stop | *N | S1* S2* |
| Start Date: Required Date: | 6/26/14 | Start Qty: 2.00 Req'd Qty: 2.00 | *9* | | Cust Item I Customer: | ID: | | | | | | |
| Reference: | | | | | • | | | | _ | a. . | | |
| Approvals: | Process Pla | an: | Date: | Tooling: SPC (Y/N): | | ate: | | | Run | Start Stop | *N | R1* |
| Sequence ID/ Work Center I | D | Operation Description | | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | t Rej Qty | | Reject Number | Insp. Stamp |
| 140 *140 * | | White Gloss(Ref:4.3.5.2) | 7773573 | 0.00 | | | | 2 | d | 14 | 1-9- | 12 g |
| Powder Coating | | Memo START TIM OVEN TEM FINISH TIM | 1E: 4.55 IPERATURE: 1/60 IE: 10.35 | 0.00 | | | | | | | | |

Wing Walk as per dwg QSI005 4.4 Batch // 129 Colot 145 *145*
HandFinish Memo
Wing Walk B 14/24811 0.00

0.00 QC3- Inspect Part Finish 150

150 0.00

Memo Quality Control

Hand Finishing

Page 3

0AS 34 9-89

| DQA: | | | Date: | | | | | | | | | | TAART |
|-----------------------|---------------------------|-----------|-------------|-------|----------|------------------------------|------|----------|--------------------|-----------|--------------|---------------|--------------------|
| | | | | | | WORK ORDER NON | I-CC | ONFO | RMANCE / UF | | | – | AEROSPACE |
| QA Closed: | | | Date: | | | | | | | W | ork Order up | odate only | |
| Work Orde | ·r· | | | | | DISPOSITION | | | | AGAINST D | EPARTMENT, | /PROCESS | |
| Work Orde | - | | | | | Rework | ٦ | | Skid-tube | Crosstube | 7 | Water Jet | Engineering |
| Part N | io. | | | | | Scrap | 1 | | Machining | Small Fab | Pro | d. Eng. Coor. | Quality |
| | - | · · · | | | | Use-as-is | 1 1 | | noforming | Finishing | | re/Packaging | Other |
| NCR N | lo | | | | | Suspected Unapproved |] | | Large Fab | Composite |] | Supplier | |
| Root | | <u></u> | | | Desc | ription of work order update | T | Initial | Acti | ion | Sign & | | |
| Cause | | Date | Step | Qty | | or non-conformance | Ch | ief Eng | Descr | iption | Date | Verification | QC Inspector |
| Design | | | | | | | | | | | | | |
| Doc/Data | | | | | | | | | | • | | | |
| Equip/Tooling | _ | | ļ | | | | | | | | | | |
| Handling/Pre | | | | | | | | | | | | | |
| Material | | | | | | | | | | | | · | |
| Operator | , 📙 | | | | | | | | | | | · | |
| Offset/Setup | | | | | | | | | | | | | |
| Process | | | | | | | | | | | | ļ | |
| Supplier | \dashv | | | | | | | | | | | | |
| Training Transport | Н | | | | | | | | | | | | |
| Unapproved | \vdash | | | | , | | | | · | | | | |
| Onapproved | 1 | | I. | | L | | FA | ULT CA | TEGORY | | | | |
| Landir | ng G | iear | | | | General | | | <u>, e</u> | | | | |
| | | Bending | | | | Bend | | Folio/F | Program | · | Outside Dim | ensions | Pressure/Forced |
| | П | Centre No | ot Concer | ntric | <u> </u> | BOM/Route | | Grain | | | Over/Under | tolerance | Set-up |
| | Cracks Broken/Damage/Defe | | | | | | | Hardwa | are | | Part Incorre | ct | Temperature/Cure |
| | | Crimp/Kii | nk/Ripple | /Wave | | Burrs | | Inspect | ion Incomplete/Un | qualified | Part Lost/M | issing | Weld |
| Cuffs Contamination | | | | | | | | Instruct | tions Incomplete/L | Inclear | Part Moved | Ĺ | Wrong Stock Pulled |
| | | Crushing | | | | Countersink | | Misalig | gned/off center | | Positioned V | Vrong | |
| ' | | Heat Trea | at | \$ | | Cut Too Short | | Mislabe | eled | | Power Loss/ | 'Surge | Other |
| | | Inspectio | n Strip in | Tube | | Drawing | | Misrea | d | | | | |
| | | Marks/Ch | natter | | | Drill Holes | | Off-set | | | | | |
| | | Turning S | Sequence | | | Finish | | - | Calibration | | | | |
| | | Wave/Tw | vist in Tuk | эе | | Fit/Function | | Out of | Sequence | | | | |

| Work Ord Thursday, June | | | | *121 | 1526* | | | | | | Page 4 |
|--|----------------------|------------------------------------|-------------------------|----------------------|--------------------------|------------|--------------|---------------|---------------|------------------|---------------------------|
| Item ID: Revision ID: Item Name: | D3436-044 Step RH | | | Accept | *N900 | <u>040</u> | 100 |)* ፡ | Setup Sta | 1.71 | S1* S2* |
| Start Date: Required Date Reference: | 6/26/14 | Start Qty: 2.00 Req'd Qty: 2.00 | *9* | | Cust Item I Customer: | D: | | · _ | G. | | |
| Approvals: | Process Pla | nn: | Date: | Tooling: | Da | ate: | _ | ŀ | Run Sta | ^I <i>V</i> I | R1* |
| · · · · · | QC: | | Date: | _ SPC (Y/N): | Da | ate: | | | Sto | , *N | R2* |
| Sequence ID/ Work Center I | ID | Operation Description | | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
| 155 | | | | 0.00 | | | | 0 | | | DAS 36 14 OA 15 989 |
| *155* Small Fab | | Memo Bond pads j | per dwg and QSI 015 | 0.00 | | | | Ø×_ | | | <u> </u> |
| 160 | | QC5- Inspect part comp | leteness to step on W/O | 0.00 | | | | | | | DAS 38 |
| *160* QC Quality Control | | Memo | | 0.00 | | | | 2 | | | 9-88 /Y-9-/ |

170

Identify as per dwg & Stock Location: PP12/767 0.00

170Packaging

Memo

0.00

2 7614-9-12

Packaging

| DQA: | | Da | ate: _ | | | | | | | | | | | TAACT |
|---------------|------------------------|-------------|--------|-------|----------|-----------------------------------|----------|---------|----------------------------|----------|----------------|---------------|----------|---------------------|
| | | | | | | WORK ORDER NON | -CC | ONFO | RMANCE / UPDATE | | | | | AEROSPACE |
| QA Closed: | | Da | ate: | | | | | | | W | ork Order up | date only | | |
| Mork Order | | | | | | DISPOSITION | | | AGAINS | DE | PARTMENT | PROCESS | | |
| Work Order | . — | | | | | Rework | 1 | | Skid-tube Crosstube | . [| | Water Jet | <u> </u> | Engineering |
| Part No | 1 | | | | | Scrap | 1 | | Machining Small Fal | _ | Pro | d. Eng. Coor. | | Quality |
| Tarene | J | | | | | Use-as-is | 1 | | noforming Finishing | | | e/Packaging | | Other |
| NCR No | э. | | | | | Suspected Unapproved | 1 | | Large Fab Composite | | | Supplier | | |
| | | | | | | | , | | | | | | | |
| Root | | | | | Desci | ription of work order update | I | nitial | Action | | Sign & | | | |
| Cause | D | ate St | ер | Qty | | or non-conformance | Ch | ief Eng | Description | | Date | Verificatio | n | QC Inspector |
| Design | | | | | | | | | | | | | | |
| Doc/Data | | | İ | | | | | | | | | | | |
| Equip/Tooling | | | | | | | | | | | | | | |
| Handling/Pre | _ | | 1 | | | | | | | | ' | | | |
| Mațerial | | | | | | , | | | | | | | | |
| Operator | | | | | | | | | | | | | | |
| Offset/Setup | | | | | | | | | | | | | | |
| Process | 4 | İ | | | | | | | | | | | | |
| Supplier | _ | | | | | | | | | | | | | |
| Training | 4 | | | | | | İ | | | | | | | |
| Transport | _ | | | | | | | | | | | | | |
| Unapproved | | | | L | | | | | | | | | | <u></u> |
| | | | | - | | | FAI | ULI CA | TEGORY | | | · | | |
| Landin | | | | | | General امسط | _ |];_/c |) wa awa na | | Outside Dim | onsions | Г | Pressure/Forced |
| - | Ben | _ | | | - | Bend BOM/Boute | - | Grain | Program | \vdash | Over/Under | | ┢ | Set-up |
| | | tre Not Co | oncen | itric | - | BOM/Route Broken/Damage/Defect | _ | 1 | 250 | \vdash | Part Incorre | | - | Temperature/Cure |
| - | Cracks | | | | | 1 ' ' ' | - | Hardwa | ion Incomplete/Unqualified | - | Part Lost/Mi | | - | Weld |
| - | Crimp/Kink/Ripple/Wave | | | | | Burrs Contamination | \vdash | 4 ' | tions Incomplete/Unclear | \vdash | Part Moved | 331118 | - | Wrong Stock Pulled |
| | Crushing | | | | | Countersink | | 4 | gned/off center | - | Positioned V | Vrong | Щ. | 1 World Stock Funcu |
| - | | t Treat | | | <u> </u> | Cut Too Short | \vdash | Mislabe | | \vdash | Power Loss/ | _ | Г | Other |
| | | ection Str | in in | Tube | - | Drawing | | Misrea | | L | 1. 04.6. 2033/ | 0- | L | 1 |
| | | ks/Chatte | | ·ube | | Drill Holes | \vdash | Off-set | | | | ··· | | |
| - | | ning Seque | | | <u> </u> | Finish | \vdash | 4 | Calibration | | | | | |
| | _ | ve/Twist in | | | | Fit/Function | | 4 | Sequence | | | | | |

| Work Ord Thursday, June | | | | *121 | 1526* | | | | | | | Page | 5 |
|---|----------------------|--|----------------------|------------------------|--------------------------|------------|--------------|---------------|---------------|---------------|------------------|----------------|----------|
| Item ID: Revision ID: Item Name: | D3436-044 Step RH | | | Accept | *N900 | 040 | 100 |)* | Setup | Start Stop | | S1* S2* | |
| Item Name: Step RH Start Date: 6/26/14 Start Qty: Required Date: 6/26/14 Req'd Qty: Reference: | | | *9* | | Cust Item I Customer: | D: | | | | | | | |
| Reference: Approvals: Process Plan: QC: | | an: | Date: | Tooling: SPC (Y/N): | | ate: | | | Run | Start Stop | | R1* R2* | |
| Sequence ID/ Work Center l | ID | Operation Description QC21- Final Inspection | - Work Order Release | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | t Reje Qty | | Reject Number | Insp. Stamp | <u> </u> |

0.00

Memo

180

Quality Control

14/9/17 D Ary-9-16

| DQA: | | | Date: | | | | | | | | | | TAART |
|-----------------------|------------------------------|-------------|-------------|-------|----------|------------------------------|---------|---------|--------------------|-----------|--------------|---------------------------------------|--------------------|
| QA Closed: | | | Date: | | | WORK ORDER NON | -CC | ONFO | RMANCE / UP | | Vork Order u | ndate only [| AEROSPACE |
| QA Closed. | | | Date. | | | | | | | | | , , , , , , , , , , , , , , , , , , , | |
| Work Orde | r. | | | | | DISPOSITION | | | | AGAINST D | EPARTMENT | /PROCESS | |
| i violik Olac | ·· - | | | | | Rework |] | | Skid-tube | Crosstube | | Water Jet | Engineering |
| Part N | ο. | | | | | Scrap | 1 | | Machining | Small Fab | Pro | d. Eng. Coor. | Quality |
| | - | | | | | Use-as-is | | Therr | moforming | Finishing | Rec/Sto | re/Packaging | Other |
| NCR N | o | | | | | Suspected Unapproved | | | Large Fab | Composite | | Supplier | |
| | | | | | | | | | | | | <u> </u> | |
| Root | | | | | Desc | ription of work order update | 1 | nitial | Acti | | Sign & | | |
| Cause | _ | Date | Step | Qty | | or non-conformance | Ch | ief Eng | Descri | iption | Date | Verification | QC Inspector |
| Design | _ | | | ŧ | | | | | | | | | |
| Doc/Data | _ | | | | | | | | | | 1 | | |
| Equip/Tooling | \dashv | | | | | | | | | | | | |
| Handling/Pre | | | | | | | | |] | | | | |
| Material | | | | | | 1 | | | | | | | |
| Operator | | | | | | | | | | | | H | |
| Offset/Setup | \dashv | | | | | | | | | | | | |
| Process | \dashv | | | | | | | | | | : | | |
| Supplier | | | | | | | | | | | | | |
| Training Transport | \dashv | | | | | | | | | | | | ľ |
| Unapproved | _ | | | | , | | 1 | | | | | | |
| опарріотец | 1 | | 1 | | <u> </u> | | FA | ULT CA | TEGORY | | | | |
| Landin | ng G | iear | | | | General | | , | | | | | |
| Г | _ | Bending | | | | Bend | | Folio/F | Program | | Outside Dim | iensions [| Pressure/Forced |
| | | Centre N | ot Concer | ntric | | BOM/Route | | Grain | | | Over/Under | tolerance | Set-up |
| | | Cracks | ├─ │ | | | | | Hardwa | are | | Part Incorre | ci [| Temperature/Cure |
| Ī | Crimp/Kink/Ripple/Wave Burrs | | | | | | | Inspect | tion Incomplete/Un | qualified | Part Lost/M | issing | Weld |
| | Cuffs Contamination | | | | | | | Instruc | tions Incomplete/U | Inclear | Part Moved | L | Wrong Stock Pulled |
| [| | Crushing | | | | Countersink | | Misali | gned/off center | | Positioned \ | | |
| | | Heat Trea | at | | | Cut Too Short | | Mislab | eled | | Power Loss | 'Surge | Other |
| [| | Inspectio | n Strip in | Tube | | Drawing | | Misrea | d | | | · ··· | |
| | | Marks/Cl | natter | | | Drill Holes | L | Off-set | | | | | |
| | | Turning S | Sequence | | | Finish | <u></u> | 4 | Calibration | | | | |
| | | Wave/Tw | vist in Tul | be | | Fit/Function | | Out of | Sequence | | | | |

Picklist Print

Thursday, June 26, 2014 3:02:23 PM

Work Order ID: 121526

121526

D3436-044 Parent Item:

Parent Item Name: Step RH

D3436-044

Start Date: 6/26/14

Required Date: 6/26/14

Page 1

Start Oty: 2.00 Required Qty: 2.00

Comments:

IPP A 05.05.11New IssueKJ/JLM

| Component Item ID/ tem Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|--------------------------------|------------------------|---------------|-------------|---------------------|---------------------------------------|-----------------|-----------------|----------------|------------------|--------------|---------------|----------------|-------------------|
| 03436-5 | | Manufactured | No | | · · · · · · · · · · · · · · · · · · · | 100 | Each | 53.0000 | 4 | 8 | | | 4. 20 |
| *D3436-5* | • | | | | | | | | ** | | | | 14-09-0 |
| | | | | Location | | Loc | <u>Oty</u> | Loc Code | | | | | |
| | | | | WA002 | | | 53 | | | | _ | | |
| | | | | ç | 105968 | | 4 | | . | (a) 1 | _ | | |
| | | | | | 110527 120944 | | 21 24 | | Ĩ | 81 | _ | | |
| | | | | | 97483 | | 4 | | . – | | | | |
| 3436-7 | | Manufactured | No | | | 100 | Each | 14.0000 | 1 | 2 | | | |
| D3436-7* | | | | | | | | | ** | | | | 14-09- J9 |
| np | | | | | | t | | | - | | | | V |
| | | | | Location | | Loc | | Loc Code | | | | | |
| | | | | WA002 ▼ | 95795 | | 14 14 | | 7 | 21 | _ | | |
| 3436-9 | | Manufactured | No | <u> </u> | 93793 | 100 | Each | 13.0000 | 2 | 4 | _ | | / nas |
| | • | Manufactured | | | | | | | ** | 7 | 16 | nale | DAS 36 9-89 |
| 'D3436-9' | • | | | | | | | | _ | | -/// | 07//3 | 9.89 |
| | | | | Location | | Loc | <u>Oty</u> | Loc Code | | | 10 | / | |
| | | | | ST038 | | | 13 | | | | _ | | |
| | | | | | 105682 | | 13 | | _ | 4_ | _ | | |
| 03436-4 | | Manufactured | No | | | 100 | Each | 4.0000 | 1 | 2 | | | |
| 503436-4 ³ | * | | | | | | | | ** | | | | 14-09-0 |
| | | | | Location | i. | Loc | <u>Qty</u> | Loc Code | | | | | 12 |
| | | | | WA002 | , | | 4 | | , , ' | 9.1 | _ | | |
| | | | | | 97510 | | 4 | | Ī | ٨ | _ | | |

| DQA: | | Date: | | | | | | | | | | | DART |
|---------------|------------------------|---------------|--------------|------------------|------------------------------|----------|---------|--------------------|-----------|----------|--------------|---------------|--------------------|
| QA Closed: | | Date: | | | WORK ORDER NON- | -CC | ONFO | RMANCE / UF | | ۱۸/، | rk Order up | ndate only | AEROSPACE |
| QA Ciosea. | | Date. | | | | T | | | | _ | | • | |
| Work Orde | ır. | | | | DISPOSITION | | | | AGAINST | DE | PARTMENT | /PROCESS | |
| WOIK OIGE | | | | - . i | Rework | 1 | | Skid-tube | Crosstube | |] | Water Jet | Engineering |
| Part N | 0. | | | | Scrap | | | Machining | Small Fab | | Pro | d. Eng. Coor. | Quality |
| | | | | | Use-as-is | | | noforming | Finishing | | ŧ. | re/Packaging | Other |
| NCR N | lo. | | | | Suspected Unapproved | | | Large Fab | Composite | | | Supplier | |
| | | | | | | | | | | | | , | |
| Root | | | | Desc | ription of work order update | ı | nitial | Acti | | | Sign & | | |
| Cause | Date | Step | Qty | | or non-conformance | Ch | ief Eng | Descri | iption | | Date | Verification | QC Inspector |
| Design | | | | | | | | | | | | | |
| Doc/Data | | | | | | ĺ | | | | | | | |
| Equip/Tooling | | | | | | | | | | | | | |
| Handling/Pre | | | | | | | | | | | | | |
| Material | H ! ! | | | , | | | | į. | | | | | |
| Operator | tor 🔲 | | | | | | | | | | | | |
| Offset/Setup | | | | | | | | | | | | | |
| Process | | | | | | l | | | | | | ļ | |
| Supplier | | | | | | | | | | | | | |
| Training | | | | | | | | | | | | | |
| Transport | | | | , | | | | | | | | | |
| Unapproved | | | | | | <u> </u> | | | | | <u> </u> | <u> </u> | |
| | | | | | | FAI | ULT CA | TEGORY | | | | | · |
| Landir | ng Gear | | | | General | | 1 | | | _ | 1 | | ¬- ,- , |
| ļ | Bendi | • | | | Bend | | 4 | Program | | | Outside Dim | | Pressure/Forced |
| | _ | Not Conce | entric | | BOM/Route | | Grain | | | _ | Over/Under | _ | Set-up |
| | Cracks | | | <u> </u> | Broken/Damage/Defect | | Hardwa | | | <u> </u> | Part Incorre | _ | Temperature/Cure |
| ļ | Crimp/Kink/Ripple/Wave | | | | Burrs | \vdash | 1 | ion Incomplete/Un | | _ | Part Lost/M | _ | Weld |
| | Cuffs | | | | Contamination | _ | 4 | tions Incomplete/L | Inclear | L | Part Moved | <u> </u> | Wrong Stock Pulled |
| | Crushing | | | igspace | Countersink | <u></u> | • | gned/off center | | _ | Positioned \ | _ | ا |
| | Heat Treat | | | | Cut Too Short | | Mislab | | | <u> </u> | Power Loss/ | 'Surge | Other |
| • | | tion Strip ir | ո Tube | | Drawing | | Misrea | | | | | | |
| ļ | | /Chatter | | | Drill Holes | | Off-set | | | | | | |
| | | g Sequence | | Ŀ | Finish | | 4 | Calibration | | | | | |
| | Wave | Twist in Tu | be | | Fit/Function | L | Out of | Sequence | | | | | |

Picklist Print

Thursday, June 26, 2014 3:02:23 PM

Work Order ID: 121526

Parent Item:

D3436-044

Parent Item Name: Step RH

121526 *D3436-044*

Start Date: 6/26/14

**

Required Date: 6/26/14

Page 2

Start Qty: 2.00

Required Qty: 2.00

D3436-1

Manufactured No

155

Each

30.0000

2

D3436-1

Clamp

Location

WA002

Loc Qty

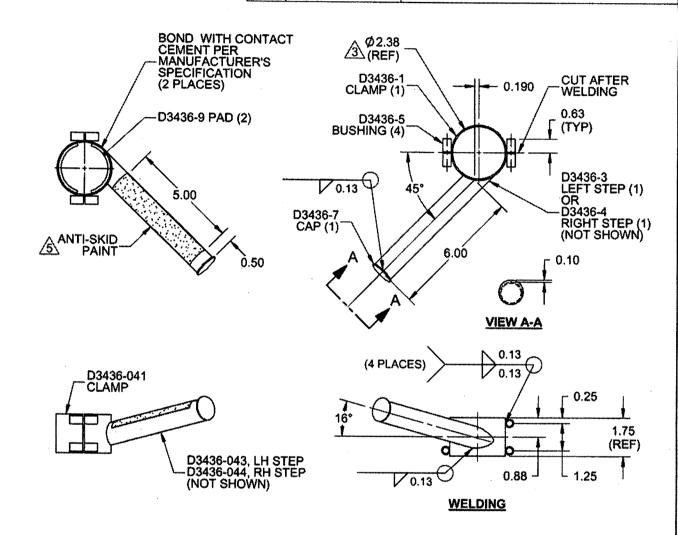
Loc Code

30 30

| DQA: Date: | | | | - DART | | | | | | | | | | |
|--------------------------|------------------------|-----|------|---|---------------|-----------------------------|-----------------------|-------------------------------|-------------------------------|-------------------------------------|-------------------|------------|-------------------------------------|---------------------------|
| QA Closed: Date: | | | | WORK ORDER NON-CONFORMANCE / UPDATE Work Order update only | | | | | | | AEROSPĀCĒ | | | |
| | | | | | | DISPOSITION | | AGAINST DEPARTMENT/PROCESS | | | | | | |
| Work Orde | er: | | | | | l | | | | | | | | 1 |
| Part No. | | | | | - | Rework Scrap Use-as-is | | | Skid-tube Machining noforming | Crosstube Small Fab Finishing | | | Water Jet d. Eng. Coor. e/Packaging | Engineering Quality Other |
| NCR N | lo. <u> </u> | | | | _ | Suspected Unapproved | | | Large Fab | Composite _ | | | Supplier | |
| Root | | | | | Desci | iption of work order update | | nitial | Actio | n | | Sign & | | |
| Cause | D | ate | Step | Qty | | or non-conformance | Ch | ief Eng | Descrip | tion | | Date | Verification | QC Inspector |
| Design | | | | | | | | | | | | | | |
| Doc/Data | | | | | | | | | | | | | | |
| Equip/Tooling | | · | | İ | | | | | | | | | | |
| Handling/Pre | | | | | | | | | | | | | | |
| Material | | | | | | | | | | • | | | | |
| Operator | | | | | | | | | | | | | | |
| Offset/Setup | | : | | | | | | | | | | | | |
| Process | | | | | | ! | | | | | | | | |
| Supplier | | | | | | | | | : | | ĺ | | | |
| Training | | | | | | | | | | | | | | |
| Transport | | | | | | | | | | | | | | |
| Unapproved | | | | | ĺ | | | | | | | | | |
| | | | | | | | FAI | ULT CA | TEGORY | | | **** | ·— | <u> </u> |
| Landi | ng Gear | • | | | | General | | _ | | _ | | | _ | - |
| | Bending | | | | Bend | | Folio/Program | | | | Outside Dim | ensions | Pressure/Forced | |
| | Centre Not Concentric | | | ntric | | BOM/Route | Grain | | | | | Over/Under | tolerance | Set-up |
| | Cracks | | | | | Broken/Damage/Defect | | Hardware | | | Part Incorrect | | Temperature/Cure | |
| | Crimp/Kink/Ripple/Wave | | | | Burrs | Inspectio | | ection Incomplete/Unqualified | | | Part Lost/Missing | | Weld | |
| | Cuffs | | | | | Contamination | | Instruc | ons Incomplete/Unclear | | | Part Moved | | Wrong Stock Pulled |
| | Crushing | | | | Countersink | | Misaligned/off center | | | | Positioned Wrong | | - | |
| Heat Treat | | | | Cut Too Short | | Mislabeled | | | | Power Loss/Surge | | Other | | |
| Inspection Strip in Tube | | | | Drawing Misr | | | d | | | | | | | |
| | Marks/Chatter | | | | | Drill Holes | | Off-set | | | | | | |
| | Turning Sequence | | | | | Finish | | Out of | Calibration | | · | | | |
| | Wave/Twist in Tube | | | | Γ | Fit/Function | Out of Sequence | | | | | | | |



| DESIGN N | IB | DRAWN BY MB | DART AEROSPACE HAWKESBURY, ONTARIO, CA | |
|-------------|------|----------------|---|------------------------|
| CHECK | ##- | APPROVED # | DRAWING NO. D3436 | REV. A SHEET 1 OF 4 |
| DATE | 05.0 | 14.28 | MAINTENANCE STEP | SCALE 1:4 |
| Α | 0 | 5.04.28 | NEW ISSUE | |



NOTES:

1) POSITION PARTS AS PER JIGS DT8772 AND DT8773
2) WELD PER DART QSI 004
3) FILLET BOTH TOP AND BOTTOM EDGES OF CLAMP ALONG 2.38 I.D. SECTION TO 0.03 RADIUS TO PREVENT SCORING AND SCRATCHING OF SKID CROSS TUBE
4) FINISH: POWDER COAT WHITE GLOSS (4.3.5.2) PER DART QSI 005 4.3
5) APPLY BLACK ANTI-SKID PAINT AS SHOWN PER DART QSI 005 4.4
6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
7) ALL DIMENSIONS ARE IN INCHES

RELEASEL 05.05.27

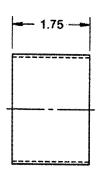
> UNCONTROLLED COP SUBJECT TO AMENDMENT ENGINEERING

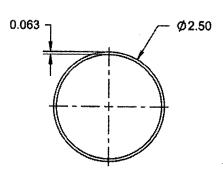
SHOP COPY

COPYRIGHT © 2005 BY DART AEROSPACE LTD.



| DESIGN MB | DRAWN BY MB | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | | | | | |
|--------------|----------------|--|------------------------|--|--|--|--|
| CHECKED | APPROVED # | DRAWING NO. | REV. A SHEET 2 OF 4 | | | | |
| DATE 05.0 |)4.28 | MAINTENANCE STEP | SCALE 1:2 | | | | |

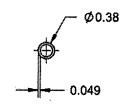




D3436-1 CLAMP

1) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T2500W063)





D3436-5 BUSHING

2) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T0375W049)

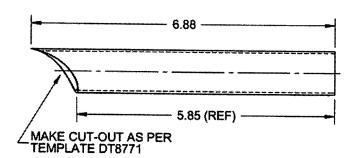


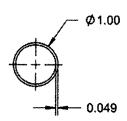
D3436-1/-5, GENERAL NOTES:

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 4) ALL DIMENSIONS ARE IN INCHES 5) BREAK ALL SHARP EDGES 0.005 TO 0.010



| DESIGN MB | DRAWN BY MB | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | | | | |
|--------------|-------------|--|------------------------|--|--|--|
| CHECKED | APPROVED | DRAWING NO. D3436 | REV. A SHEET 3 OF 4 | | | |
| DATE 05.0 |)4.28 | MAINTENANCE STEP | SCALE 1:2 | | | |

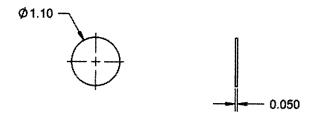




D3436-3 LEFT STEP

(D3436-4 RIGHT STEP - OPPOSITE, NOT SHOWN)

1) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T1000W049)



D3436-7 CAP

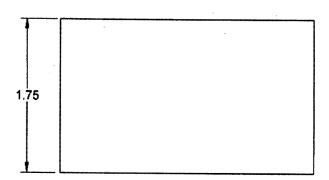
2) MATERIAL: AISI 4130N STEEL SHEET PER MIL-S-18729, AMS6350 OR AMS 6351 (REF. DART SPEC. M4130N-S050)

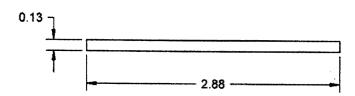
D3436-3/-7, GENERAL NOTES:

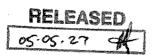
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 4) ALL DIMENSIONS ARE IN INCHES 5) BREAK ALL SHARP EDGES 0.005 TO 0.010



| DESIGN MB | DRAWN BY MB | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | | | | |
|--------------|----------------|--|------------------------|--|--|--|
| CHECKED | APPROVED # | DRAWING NO. D3436 | REV. A SHEET 4 OF 4 | | | |
| DATE 05.0 | 04.28 | MAINTENANCE STEP | SCALE 1:1 | | | |







D3436-9 PAD

NOTES:

- 1) MATERIAL: 60 DUROMETER NEOPRENE SHEET, 1/8" THICK (REF. DART SPEC. M-NEO60-S.125)
 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 3) ALL DIMENSIONS ARE IN INCHES

COPYRIGHT © 2005 BY DART AEROSPACE LTD.